

Work Order ID 110495

December-23-13 9:51:18 AM

110495

Rev A 5/3/24
~~ADVISE~~
~~ILLUMINATE~~

Page 1

Item ID: D5021-3

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Foam

Stop

NS2

Start Date: 12/23/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: U

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

DAS

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

27

9-89

D5021

~~pa2~~ Rev A

DAS

10

9-89

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PA2

Prog Rev: PA2

2-Debur if necessary

1 EL 13-12-23

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

1 B 13/12/23

Work Order ID 110495

110495

Page 2

December-23-13 9:51:18 AM

Item ID: D5021-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Foam
 Start Date: 12/23/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/23/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
			DAS 27 9-89 12/12/23			1 inspect as per dwg P90			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							OK 12/12/23
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DAS
27
9-89

POSITIVE RECALL

EFFECTIVE 12.12.23 AUTH W

RELEASED 5 DATE 12/12/24

Release DWG M05 14-01-24
 Rev A U.3.12-23

Picklist Print

December-23-13 9:51:18 AM

Page 1

Work Order ID: 110495

Parent Item: D5021-3

Parent Item Name: Foam

Start Date: 12/23/13

Required Date: 12/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5033-1 Rigid Polyurethane Foam		Manufactured	No				sf	0.0000		16		13-12-23	

M 110489 x 16 sq ft

DART AEROSPACE LTD		Work Order:	13110495
Description: foam		Part Number:	DS021-3
Inspection Dwg: DS0213 Rev: PAA		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.53	+/- 0.030	36.53	✓		T	JKm-C6
42.59	+/- "	42.720	✓		T	"
12.30	+/- "	12.280	✓		T	"
2.00	+/- "	2.00	✓		✓	JKm-es
2.78	+/- "	2.75	✓		✓	"
6.33	+/- "	6.33	✓		✓	"
5.35	+/- "	5.35	✓		✓	"
7.35	+/- "	7.35	✓		✓	"
6.75	+/- "	6.75	✓		✓	"
1.68	+/- "	1.70	✓		✓	"
1.83	+/- "	1.83	✓		✓	"
13.83	+/- "	13.83	✓		T	JKm-C6
25.83	+/- "	25.83	✓		T	"
6.26	+/- "	6.26	✓		✓	"
3.41	+/- "	3.41	✓		✓	"
17.41	+/- "	17.41	✓		T	"
31.41	+/- "	31.41	✓		T	"
2.80	+/- "	2.80	✓		✓	JKm-es
6.36	+/- "	6.36	✓		✓	"

Measured by:	JB
Date:	13/12/23

Audited by:	
Date:	

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

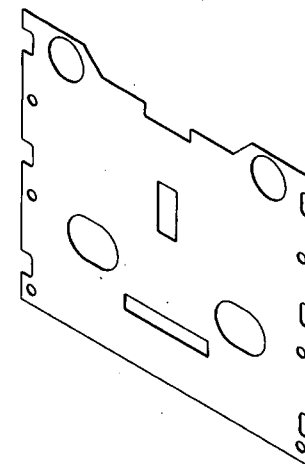
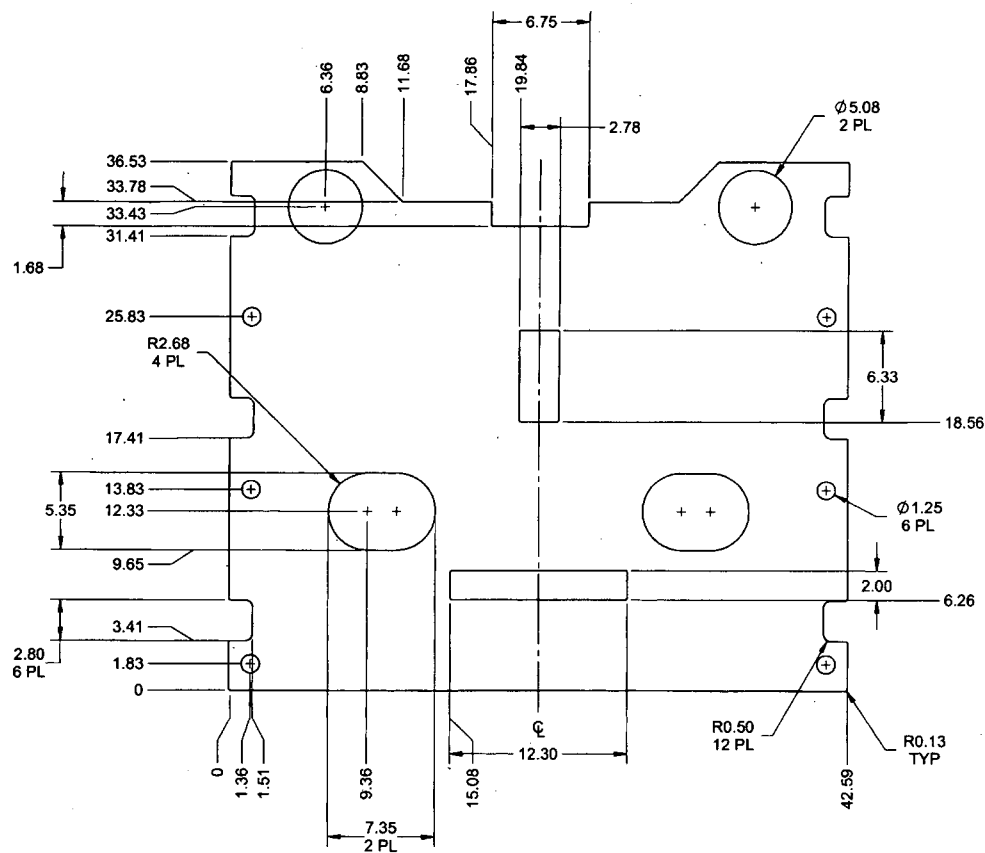
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

D5021-3 FOAM, CENTER PANEL, MIDDLE

RELEASED
2008-12-23
A-SS

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D5021	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FOAM CORE	NTS
DATE	13.12.09	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

